

Date: Tuesday, 03/02/2009 3:26:54 PM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BAR
Job Number :	45480		
Estimate Number :	13480		
P.O. Number :		Part Number :	D38061
This Issue :	03/02/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	PROTO
First Issue :	1/1	Project Number :	N/A
Previous Run :	05057	Drawing Revision :	PROTO
	Type :	Material :	
	R & D SM/MED FAB	Due Date :	06/02/2009
Written By :		Qty:	1
Checked & Approved By :		Um:	Each
Comment :	Est Rev:A 08-07-21 new issue DD verified by:ec Est Rev:B 08-09-23 redesign DD verified by:EC Est Rev:C 08-09-30 redesign DD verified by:EC		

Additional Product

Job Number:



Seq. #: **Machine Or Operation:** **Description :**

1.0 M304B0500X2500 304 BAR .500 x 2.50



Comment: Qty.: 0.8820 f(s)/Unit Total : 0.8820 f(s)
304 BAR .500 x 2.50
batch: 110253 B 9-2-4

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3806
Dwg Rev: PROTO
Prog Rev: TYPE
2-Deburr if necessary

B 9-2-4



3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 9-2-4

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 45480

Part Number: D38061

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



NOT FOR SALE
HAI ONLY

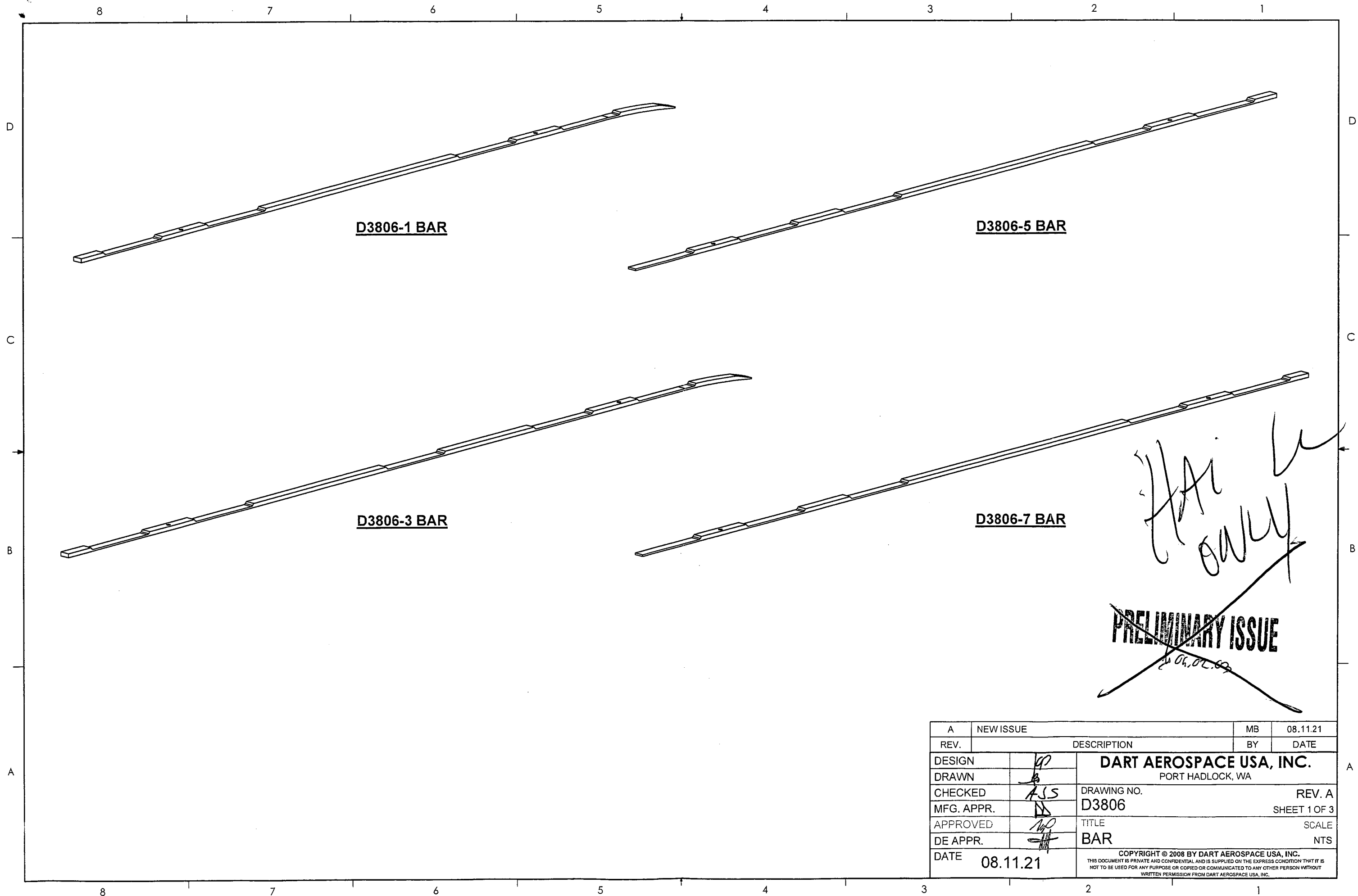


Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



60600
MK
09-02-04



A	NEW ISSUE		MB	08.11.21
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE USA, INC. PORT HADLOCK, WA		REV. A	
DRAWN			SHEET 1 OF 3	
CHECKED	DRAWING NO. D3806		TITLE	
MFG. APPR.	SCALE		NTS	
APPROVED	DATE 08.11.21		COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.	
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Ø0.188 THRU
2 PL

24.000

7.000

0.250
2 PL

32.50

25.50

8.50

4.00
TYP

1.50

0.200

0.52

R31.7

A4-2

35.68 TO BEND TANGENT

40.17

D3806-1 BAR

Ø0.188 THRU
2 PL

30.500

7.000

0.250
2 PL

38.50

31.50

21.50

8.50

4.00
TYP

1.50

0.200

0.52

R31.7

A4-2

41.75 TO BEND TANGENT

46.24

D3806-3 BAR

PRELIMINARY ISSUE

09.02.03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.500 THICK
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3806-1 = 0.87 lbs
D3806-3 = 0.98 lbs

0.080

135°

R0.13
2 PL

DETAIL A
TYP, SCALE 2X

D5-2
B6-2
C3-3
A3-3

DESIGN	JP	DART AEROSPACE USA, INC.	
DRAWN	JS	PORT HADLOCK, WA	
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	JS	D3806	SHEET 2 OF 3
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BAR	NTS
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